

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000667**Date Inspected:** 18-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG - Closed Rib Trials		

**Summary of Items Observed:**

OBG-CLOSED RIB TRIALS

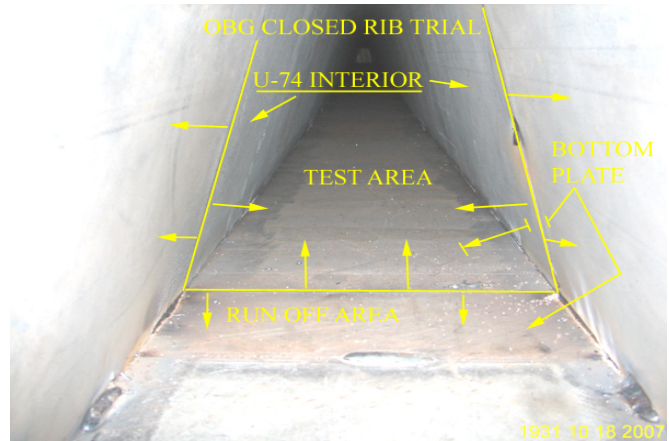
The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the OBG Closed Rib Trials. The QA Inspector observed the Submerged Arc Welding (SAW) with the gantry, of closed ribs piece marks U-74 and U-104 on Partial Joint Penetration (PJP) Weld Joint (WJ) numbers 3, 4, 7 and 8. The QA Inspector randomly observed that each WJ was placed in 2 meter increments simultaneously with the following ZPMC welder operators performing the work: WJ 3-1 through WJ3-5 Zhang Shao Kuai, WJ4-1 through WJ4-5 Tang Liang, WJ7-1 through WJ7-5 Xu Guo Yin and WJ8-1 through WJ8-5 Song Yin Shu. Each WJ was broken down into 5 separate increments and the weld parameters were recorded for WJ 3-1 through WJ3-5, WJ4-1 through WJ4-5, WJ7-1 through WJ7-5 and WJ8-1 through WJ8-5. The QA Inspector randomly observed ZPMC Quality Control personnel monitoring all weld parameters. ZPMC CWI Xu Xian Ping supervised the QC personnel monitoring the weld parameters during the Closed Rib Trials for WJ's 3, 4, 7 and 8. The QA Inspector randomly monitored the welding amperage and travel speed for WJ's 3, 4, 7 and 8 and forwarded the information to the Lead QA Inspector. The QA Inspector recorded the welding amperage and travel speed from on top of the Closed Rib Trial Assembly in front of the traveling gantry. The attached photographs provide additional details.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

There were no relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Franco,Charlie

Quality Assurance Inspector

---

**Reviewed By:** Cochran,Jim

QA Reviewer